

76212

November-07-11 2:37:45 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Bracket

40

Cust Item ID:

40

Customer:

Reference:

Run Start *NR1*

Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Draw Nbr	Revision Nbr
D3199	E

100

0.00

100

FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: **E**

Prog Rev: E

Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

Memo

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76212

76212

Page 2

November-07-11 2:37:45 PM

Item ID: D3199-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 07/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		<i>Sululu</i>		<i>counted</i> <i>(46)</i>			
130 *130* Small Fab Small Fab	Small Fab Memo Form as per dwg D3199 use DT9723	0.00 0.00		<i>Sululu</i>		<i>(46)</i>			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Sululu</i>		<i>counted</i> <i>(46)</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76212

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November-07-11 2:37:45 PM

Item ID: D3199-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 07/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 21/11/2011 Req'd Qty: 40.00 ***40*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
-----	--	------	--	--	--	--	--	--	--

150

Powdercoat

Powder Coating

Memo

START TIME: 8:20

OVEN TEMPERATURE: 320 OF

FINISH TIME: 8:50

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

170

Identify as per dwg & Stock Location: ST 230B 0.00

170

Packaging

Packaging

Memo

0.00

46 X 0 M-11/11/23

46 BL 11-11-23

46 SP 11-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76212

76212

Page 4

November-07-11 2:37:45 PM

Item ID: D3199-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 07/11/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 21/11/2011 Req'd Qty: 40.00 ***40*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

11/11/24 *[Signature]*
 21/11/24
 46

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-07-11 2:37:49 PM

Page 1

Work Order ID: 76212

76212

Parent Item: D3199-1

D3199-1

Parent Item Name: Bracket

Start Date: 07/11/2011

Required Date: 21/11/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:C Removed Scribing 05-11-05 JLM
 IPP Rev:D As per Rev B 06-11-24 JLM IPP Rev:E
 11.03.31 as per ecn 11-531 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

289.3795

0.099

4.168421

M304S20GA

11/11-16

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

289.3795

116623

0.2

117550

7.863

117933

27.3442

118400

25.6723

118964

36.5

119346

191.8

119346

46

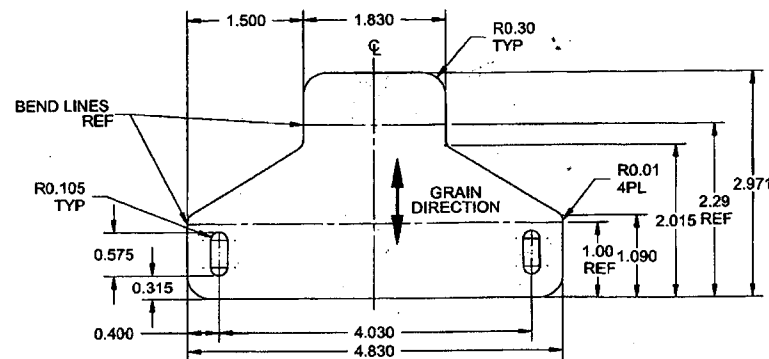
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

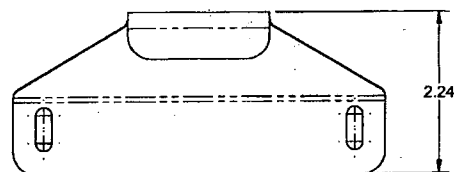
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F

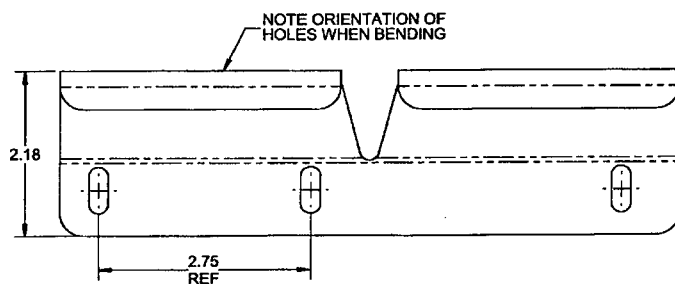
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 76212
11-11-08

RELEASED
2011-07-18
MP

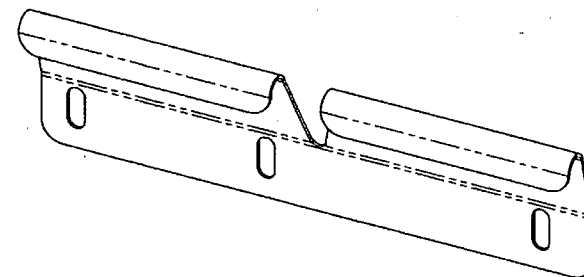
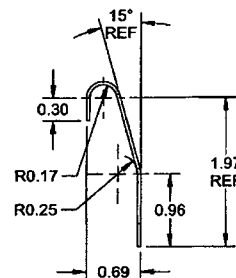
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

E	RE-DESIGNED D3199-3/-4-3F PER CUSTOMER FEEDBACK TO OPTIMIZE FIT.	MB	11.07.11
D	RE-DESIGNED D3199-3/-4-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PAR11-79	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	08.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>JP</u>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<u>JP</u>		
CHECKED	<u>JP</u>	DRAWING NO.	REV. E
MFG. APPR.	<u>JP</u>	D3199	SHEET 1 OF 4
APPROVED	<u>JP</u>	TITLE	SCALE
DE APPR.	<u>JP</u>	BRACKET	NTS
DATE	11.07.11	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



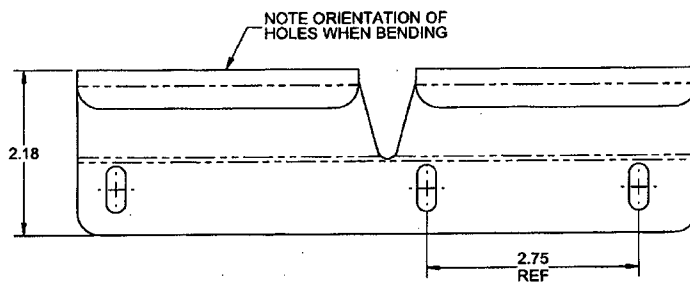
D3199-3 BRACKET
MADE FROM D3199-3F



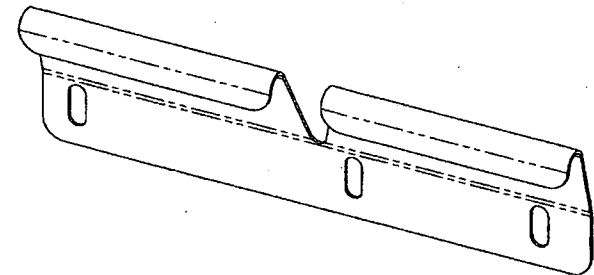
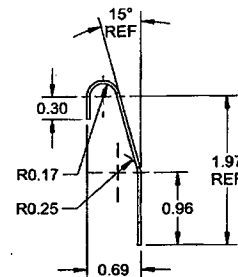
76212

RELEASED
2011-07-18
WJ

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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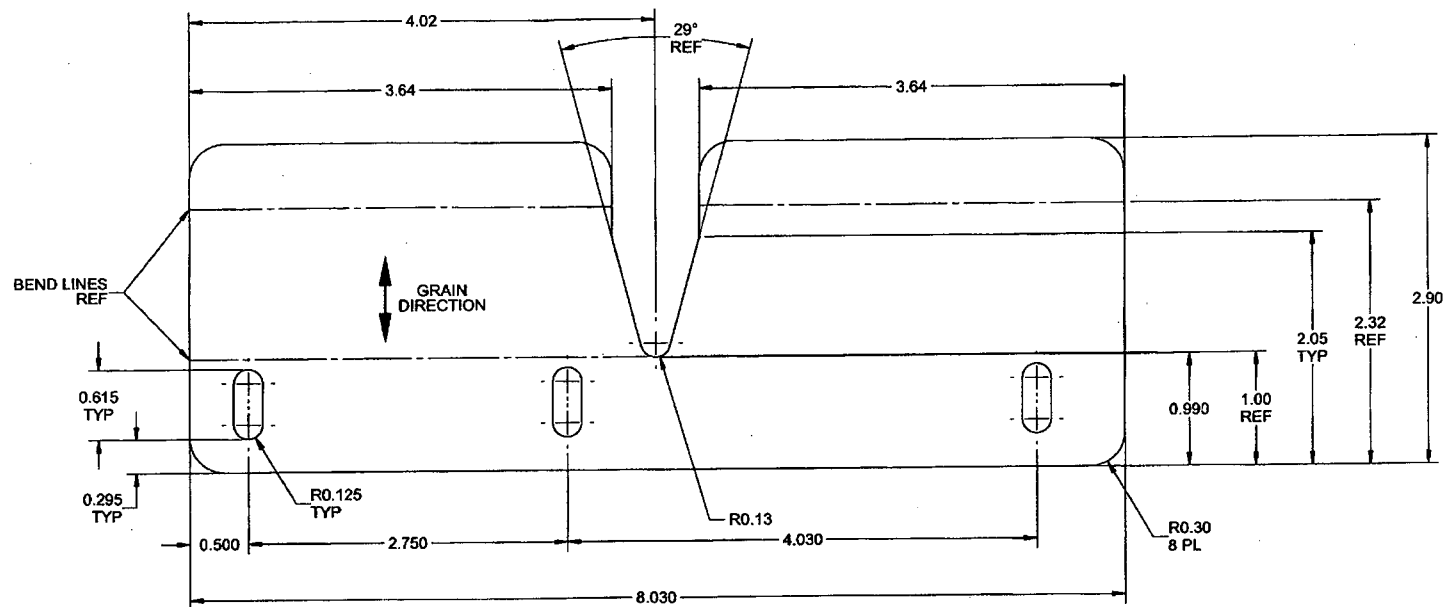
D3199-4 BRACKET
MADE FROM D3199-3F



76212

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2011-07-18
JMS

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MFG. APPR.		D3199	SHEET 3 OF 4
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D3199-3F FLAT PATTERN

RELEASED
2011-07-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5058, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3199	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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